

Work Order ID 133026

Wednesday, May 27, 2015 3:16:16 PM

133026

Page 1

Item ID: PB67-43001-29

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Blade Positioner Weldment

Start Date: 5/22/2015 Start Qty: 1.00

1

Cust Item ID:

Required Date: 6/5/2015 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: YMC Date: 5-5-27

Tooling:

Date:

Run Start ***NR1***

QC: _____ Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
B67-43001-29	C								

100

Weld per dwg A/R Aluminum rod Batch: 0.00

100

Large Fab

Large Fab

4130137

Memo

0.00

Large Fab

****FOR -337 LOCATE APPROX. AS SHOWN ASSURING 45 DEG.
MOVEMENT OF -285 EACH SIDE OF VERTICAL, PRIOR TO
WELDING****

1- ASSEMBLE AND WELD AS PER DWG

1xDAS
43

9-89

JUN 17 2015

110

QC9- Inspect visual per QSI004- Fusion Welds 0.00

110

QC

Quality Control

Memo

0.00

15-06-17

DAS

9

9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐				
Date :	Step #:	QTY Effective :			MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			Completed By	
					Lead hand / Supervisor Approval Verification	
					QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY				
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	
OTHER :						

Page 2

DAS 34 9-89

DAS
9
~~9-89~~

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order update only ☐

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Work Order ID 133026

Wednesday, May 27, 2015 3:16:16 PM

133026

Page 3

Item ID: PB67-43001-29

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Blade Positioner Weldment

Start Date: 5/22/2015 Start Qty: 1.00

1

Cust Item ID:

Required Date: 6/5/2015 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

NR1

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

150

Identify as per dwg & Stock Location: UAD004

0.00

150

Packaging

Memo

0.00

Packaging

DAS

9

9-89

0 15-06-22

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.00

Quality Control

MLJ JUN 23 2015MLJ JUN 23 2015

QA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order update only ☐

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Past Expiry Date ☐	Manufacturing Process ☐	OTHER :																							
Misidentified ☐	Past Due ☐																								

Picklist Print

Wednesday, May 27, 2015 3:16:15 PM

Page 1

Work Order ID: 133026

133026

Parent Item: PB67-43001-29

PR67-43001-29

Parent Item Name: Blade Positioner Weldment

Start Date: 5/22/2015

Required Date: 6/5/2015

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 08-06-27 new issue DD verified by:ec

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
PB67-43001-313		Manufactured	No			100	Each	1.0000	1	1			
PR67-43001-313													
Plate													

Location	Loc Qty	Loc Code
Mezz2	1	
54672	1	
PB67-43001-319		
Manufactured	No	
PR67-43001-319		
Gusset		
100	Each	1.0000
2		2
**		

MF 15-6-16

DAS
43
9-89

JUN 17 2015

Location	Loc Qty	Loc Code
Mezz2	1	
99953	1	
PB67-43001-337		
Manufactured	No	
PR67-43001-337		
Stop Plate		
100	Each	7.0000
2		2
**		

X1

B133542 → 1x

MF 15-6-16

DAS
43
9-89

JUN 17 2015

Location	Loc Qty	Loc Code
WA003	7	
131363	7	

B131363 → 2x

DQA: _____ Date: _____



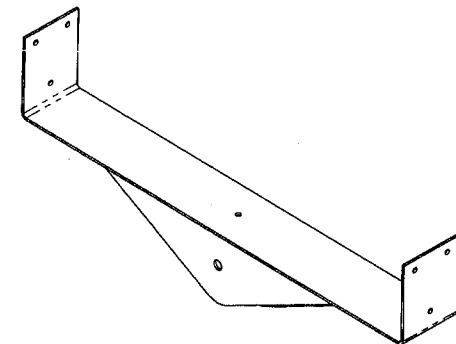
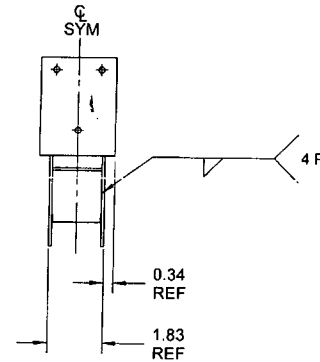
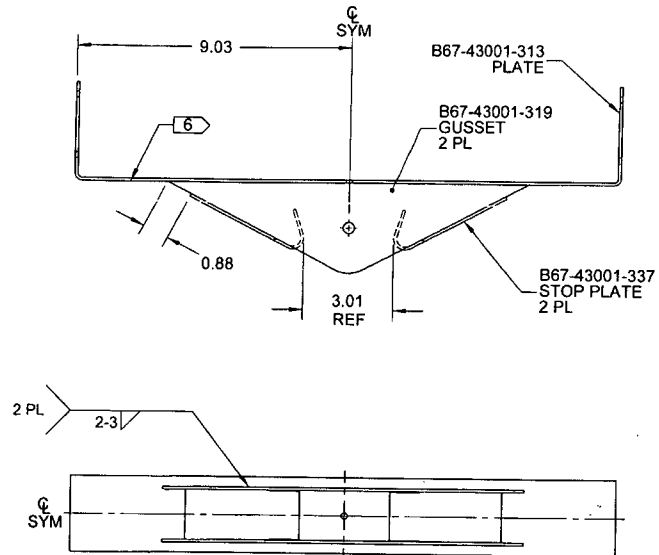
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Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions	☐
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Past Expiry Date	☐	Manufacturing Process	☐	OTHER :							
Misidentified	☐	Past Due	☐								

ITEM	QTY -29	P/N	DESCRIPTION
1	X	B67-43001-29	BLADE POSITIONER WELDMENT
3	1	B67-43001-313	PLATE
4	2	B67-43001-319	GUSSET
5	2	B67-43001-337	STOP PLATE



B67-43001-29 BLADE POSITIONER WELDMENT

mf.
133026

RELEASED
2009-09-24

- NOTES:
- 1) MATERIAL: NONE
 - 2) FINISH: POWDER COAT GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "B67-43001-29" USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: 1.01 lbs
 - 8) WELDING: PER QSI 004

C	REDRAWN PREMIER AVIATION DRAWING IAW DART QSI 018 AND QSI 043. FOR PREVIOUS REVISIONS, REFER TO SHEET 40 OF PREMIER AVIATION DRAWING No. B67-43001. REASON: SEE PAR#09-011.		MB	09.06.24
REV.	DESCRIPTION		BY	DATE
DESIGN	RW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	AS			
CHECKED	AS	DRAWING NO.	B67-43001-29	REV. C
MFG. APPR.	AS	SHEET 1 OF 1		
APPROVED	AS	TITLE	BLADE POSITIONER WELDMENT	SCALE
DE APPR.	N/A	NTS		
DATE	09.06.24	COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																		
Description Work Order Deviation				Disposition			Completed By																		
Root Cause				FAULT CATEGORY																					
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐		Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐		Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐		Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐																	
OTHER : ☐																									